

Work Order ID 138409

Tuesday, October 27, 2015 11:27:58 AM

647.7501
B 138409
REV. A

138409

Page 1

Item ID: 647.7501

Revision ID:

Item Name: Lower Cutter Assembly

Start Date: 10/26/2015 Start Qty: 2.00

Required Date: 10/26/2015 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: OCT 29 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7500	A

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

1X

16/03/2015
DAS 36 9-89

120

0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 1134260
exp. date: 07/17

1X

16/03/2015
DAS 36 9-89

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

DAS
38
9-89

MAR 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 10/26/2015 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 10/26/2015 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

MAR 24 2016

140

Identify as per dwg & Stock Location: CC low 0.00

0.00

140

Packaging

Memo

0.00

Packaging

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

1 DAS
6
9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCS APR 05 2016

MCS APR 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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OTHER : _____							

Picklist Print

Tuesday, October 27, 2015 11:27:58 AM

Page 1

Work Order ID: 138409

138409

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7813 *647 7813* ✓ Center Plate, Lower		Manufactured	No				Each	4.0000		21		16/03/22	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK114				4					
				119679				4		1			
647.7810 *647 7810* ✓ Bracket A		Manufactured	No				Each	4.0000		21		16/03/22	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck015a				4					
				136965				4		1			
647.7811 *647 7811* ✓ Bracket B		Manufactured	No				Each	4.0000		21		16/03/22	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck015a				4					
				136966				4		1			
646.3015 *646 3015* ✓ Blade		Manufactured	No				Each	7.0000		22		16/03/22	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck103				7					
				136216				7					

B 138872
220

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
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Picklist Print

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Page 2

Work Order ID: 138409

138409

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

647.7601

Manufactured No

Each 3.0000

647 7601 ✕

Lower Deflector Assembly

**

21

16/03/22

DAS
36
9-89

Location

Loc Qty

Loc Code

cck065

3

137078

3

Each 0.0000

647.7815

Manufactured No

647 7815 ✓

Fwd Bracket

3138151 (1) **

21

16/03/22

DAS
36
9-89

647.7814

Manufactured No

647 7814 ✕

Fwd Bracket

Each 0.0000

3138152 (1) **

21

16/03/22

DAS
36
9-89

647.7816

Manufactured No

647 7816 ✕

Aft Bracket

Each 0.0000

3138240 (1) **

21

16/03/22

DAS
36
9-89

647.7817

Manufactured No

647 7817 ✕

Aft Bracket

Each 0.0000

3138364 (1) **

21

16/03/22

DAS
36
9-89

Tuesday, October 27, 2015 11:27:58 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

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Page 3

Work Order ID: 138409

138409

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149FN832P

Purchased

No

Each

2,160.000

52

NAS1149FN832P ✓

Washer

**

16/03/22

DAS
36
9-89

Location

Loc Qty

Loc Code

GA	346
125268	346
ST260a	500
M133316	500
ST267	393
125268	100
M133284	293
st268	921
M130388	921

M133769

MS21042-3

MS21042L3

Purchased

No

Each

247.0000

6

MS21042-3 ✓

Nut / use MS21042L3

**

16/03/22

DAS
36
9-89

Location

Loc Qty

Loc Code

ST305	247
M128770	10
M129541	15
M129682	199
M130388	23

M133790
32

MS21042-08

MS21042L08

Purchased

No

Each

33.0000

26

MS21042-08 x

USE MS21042L08

7 total

**

16/03/22

DAS
36
9-89

Location

Loc Qty

Loc Code

ST304	25
122815	25
ST306	8
m130388	8

M134063 132

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
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Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
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Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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Work Order ID: 138409

Parent Item: 647.7501

Parent Item Name: Lower Cutter Assembly

138409

647 7501

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0332P

Purchased

No

Each

1,509.000

12

NAS1149F0332P

Washer

**

16/03/22

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

162

122063

162

ST260a

636

m128401

6

m131026

80

m131697

50

m133284

500

st268

117

123900

7

m130388

86

m133077

24

ST288

594

m133134

594

Each

479.0000

14

MS27039-08-19

Purchased

No

MS27039-08-19

Screw

**

16/03/22

DAS
36
9-89

Location

Loc Qty

Loc Code

cck007a

100

m133077

100

GA

186

m132930

186

ST273A

164

m131317

164

ST281

29

m131264

29

M134063

7x

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Picklist Print

Tuesday, October 27, 2015 11:27:58 AM

Page 5

Work Order ID: 138409

138409

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-19

Purchased

No

Each

223.0000

6

MS27039-1-19

Screw

**

DAS
36
9-89

16/03/22

Location

Loc Qty

Loc Code

cck007a

200

m133134

200

GA

20

m124326

20

ST285

3

m127904

3

M134134 (3x)

MS27039-08-24

Purchased

No

Each

391.0000

12

MS27039-08-24

Screw (MS27039-0824)

**

DAS
36
9-89

16/03/22

Location

Loc Qty

Loc Code

GA

291

124326

291

ST281

100

125654

100

6

Tuesday, October 27, 2015 11:27:58 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

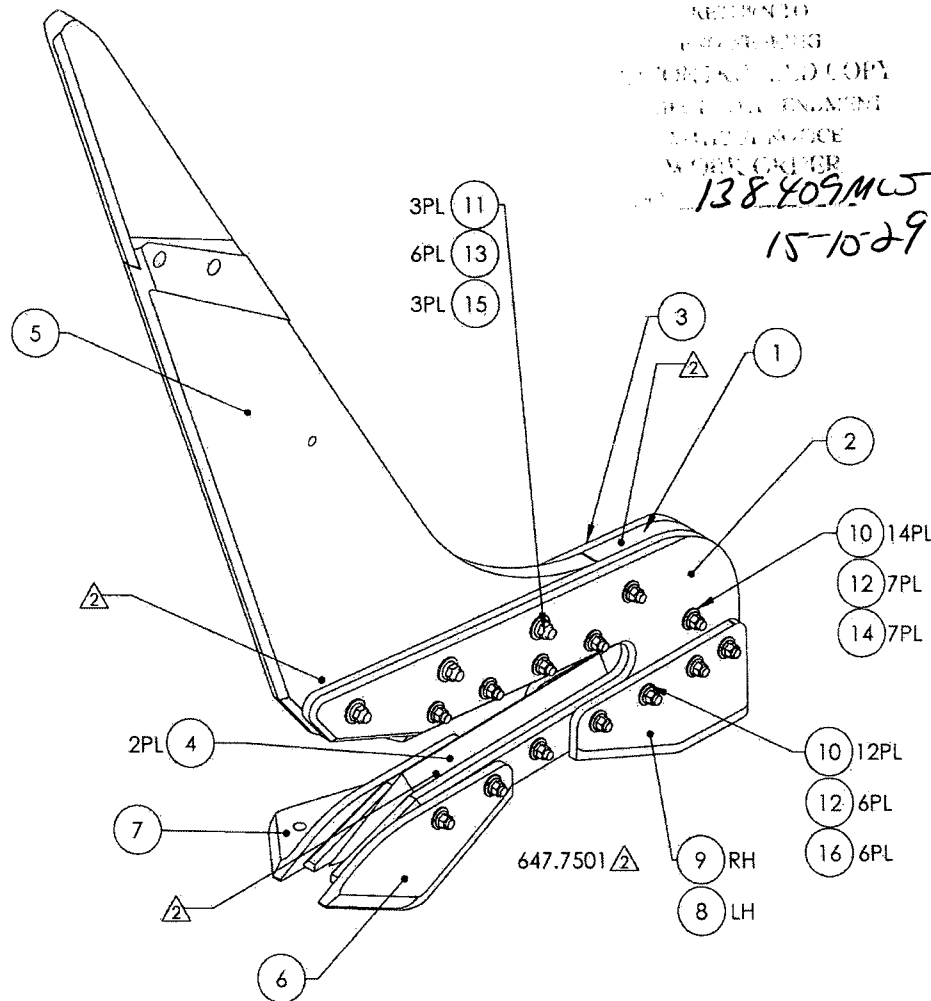
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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NOTES:

1. IDENTIFY IAW MPP-120

2. APPLY F/N 17 AS REQUIRED TO ALL FAYING SURFACES UPON ASSEMBLY



REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	AS BUILT PROTOTYPE REVISION P22		N/C
2	INITIAL RELEASE	12-21-09	P. BRAVO
3	INCORPORATED ECH 92946	07-16-10	P. BRAVO

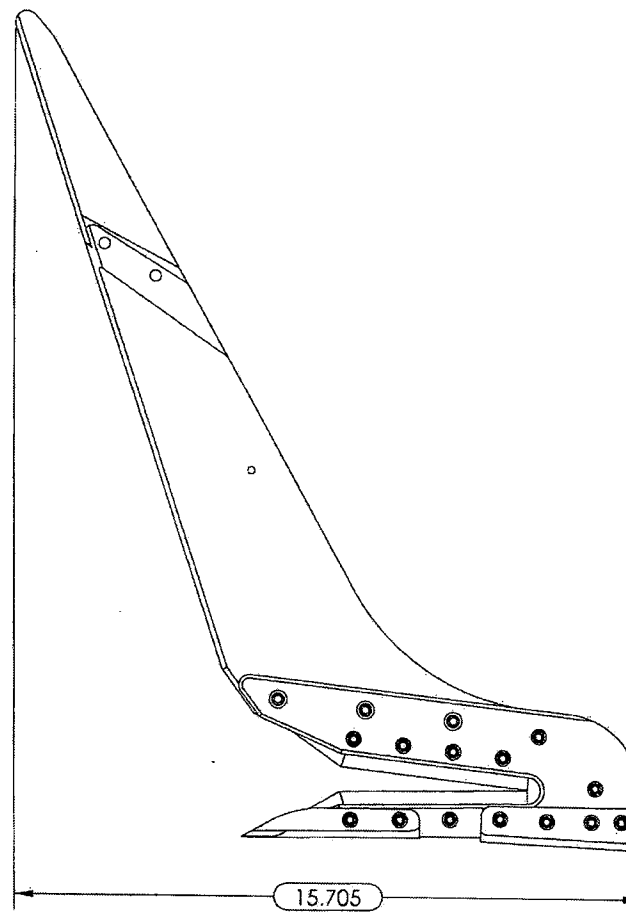
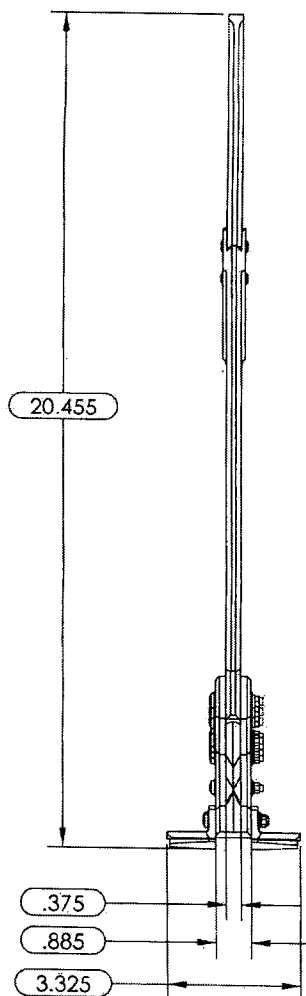
A/R	17	601.2045	RTV, LOCTITE 598		
6	16	601.3124	SCREW	MS27039-0824	
3	15	601.1948	SCREW	MS27039-1-19	
7	14	601.2765	SCREW	MS27039-0819	
6	13	601.1607	WASHER	NAS1149F0332P	
13	12	601.2973	LOCKNUT	MS21042-08	
3	11	601.2943	LOCKNUT	MS21042-3	
26	10	601.2764	WASHER	NAS1149FN832P	
1	9	647.7817	AFT BRACKET		
1	8	647.7816	AFT BRACKET		
1	7	647.7814	FORWARD BRACKET		
1	6	647.7815	FORWARD BRACKET		
1	5	647.7601	LOWER DEFLECTOR ASSY		
2	4	646.3015	BLADE		
1	3	647.7811	BRACKET B		
1	2	647.7810	BRACKET A		
1	1	647.7813	CENTER PLATE LOWER		
		647.7501	LOWER CUTTER ASSY		2
7501	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE	
647.7300		11-21-09	
		DRAWN BY	
		A. QUINN	
		CHECKED	
		P. BRAVO	
		DRAWING APPROVAL	
		12/21/09	
		CIRCUITRYING	
		UNLESS OTHERWISE SPECIFIED	
		DIMENSIONS ARE IN INCHES	
		TOLERANCES ARE:	
		3 PLACE DECIMALS ± .003	
		2 PLACE DECIMALS ± .010	
		ANGLES ± .5°	
		APICAL INDUSTRIES	
		2608 TEMPLE HEIGHTS DR.	
		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
		LOWER CUTTER ASSY	
		REV. A	
		SCALE NONE	
		SHEET 1 OF 2	

1 2 3 4 5 6 7 8

A
B
C
D

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ORIGINAL DATE (MM/DD/YY) 11-24-09		APICAL INDUSTRIES	
DRAWN BY A. GUAN		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		LOWER CUTTER ASSY	
DATE 11-21-09			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		SHEET 07M26	DWG. NO. 647.7500
TOLERANCES ARE:		SCALE NONE	REV. A
2 PLACE DECIMALS ±.01		SHEET 2 OF 2	
3 PLACE DECIMALS ±.010			
ANGLES ±.5°			